



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2893-1
Job Sheet 190932



Part No: D2893-1

Job Qty: 4 pcs

Part Name: Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/20/19

Job Tracking No:

Due Date: 2/21/19

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV C IPP: C 02.11.26 Reformat; Added P/O KJ IPP D 06.04.19 removed alodine EC IPP Rev:E Added priming as per Rev B 07-04-30 JLM IPP F 08.03.19 Re-format EC verified by: DD IPP Rev:G 08-05-15 add QC14 DD verified by:EC IPP Rev:H 11.08.04 as per dwg rev.C DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	4 pcs	2/21/19		0.33	7.84	HAAS - 1		
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
120	QC 8	4 pcs	2/21/19		0.00	0.00	QC 8 - 12		Kt 2019-02-20
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		B. 19-02-20
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
130	Crosstubes - 2 - B4B	4 pcs	2/21/19		0.00	0.67	Crosstubes - 1 - B4B		B. 19-2-20
							Crosstubes - 2 - B4B		
							Crosstubes - 3 - B4B		
							Crosstubes - 4 - B4B		
140	QC 3	4 pcs	2/21/19		0.00	0.00	QC 3 - 10		



Container No: S155184



Part: D2893-1

Job No: 190932

Serial No/Batch: S155184

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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CANADA
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Date: 02/20/19

				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 26	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 6	
				QC 3 - 68	FEB 21 2019
				QC 3 - 9	DAS 68 9-89
170	Packaging 3-1 - Stock - B4B	4 pcs	2/21/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
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					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
180	QC 21 - SA	4 pcs	2/21/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53
Part Op 100 - (HAAS CNC Vertical Machine) 1-Machine as per Folio FA081					
Descriptions: 120 - (QC8- Inspect parts - second check)					

130 - (Crosstubes) Per note 8 on page 1 of dwg D2893, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. 138852 exp 4/19

140 - (QC3- Inspect Part Finish)

170 - (Identify as per dwg & Stock Location: _____) LOCATION : LG050

180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
DSK078	D2893-1 Turning Detail	2 pcs (.5 ea)	100-HAAS 4 Axis	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	DSK078	2	12	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	2.750 Support	2.985Inches + 0.020 - 0.000	3.005 2.985		
2	2.750 Support	0.440Inches + 0.020 - 0.000	0.460 0.440		
3	2.750 Support	0.125Inches + 0.035 - 0.000	0.160 0.125		
4	2.750 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
5	2.750 Support	0.188Inches + 0.005 - 0.000	0.193 0.188		
6	2.750 Support	0.125Inches + 0.035 - 0.000	0.160 0.125		
7	2.750 Support	0.140Inches + 0.020 - 0.000	0.160 0.140		
8	2.750 Support	1.360Inches + 0.040 - 0.000	1.400 1.360		
9	2.750 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
10	2.750 Support	1.190Inches + 0.040 - 0.000	1.230 1.190		
11	2.750 Support	0.010Inches + 0.010 - 0.000	0.020 0.010		
12	2.750 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		
13	2.750 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
14	2.750 Support	2.518Inches + 0.020 - 0.000	2.538 2.518		
15	2.750 Support	84.390Inches + 6.000 - 0.000	90.390 84.390		
16	2.750 Support	0.261Inches + 0.005 - 0.000	0.266 0.261		
17	2.750 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		

Plex 2/20/19 8:35 AM dart.lacelle.linda

DART AEROSPACE LTD		Work Order:	
Description: Ø2.750 Support		Part Number: D2893-1	
Inspection Dwg: D2893		Rev: C	
		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		3.000	3.000	3.000	3.000	
AB	0.440	0.460		0.450	0.450	0.450	0.450	
AC	0.125	0.160		0.160	0.160	0.160	0.160	
AD	0.040	0.060		0.050	0.050	0.050	0.050	
AE	0.188	0.193		0.188	0.188	0.188	0.188	
AF	0.125	0.160		0.135	0.135	0.135	0.135	
AG	0.140	0.160		0.150	0.150	0.150	0.150	
AH	1.360	1.400		1.375	1.375	1.375	1.375	
AI	0.040	0.060		0.050	0.050	0.050	0.050	
AJ	1.190	1.230		1.215	1.215	1.215	1.215	
AK	0.010	0.020		0.010	0.010	0.010	0.010	
AL	0.053	0.073		0.0625	0.0625	0.0625	0.0625	
AM	0.240	0.260		0.250	0.250	0.250	0.250	
AN	2.518	2.538		2.524	2.524	2.524	2.524	
AO	84.39	90.39		87.39	87.39	87.39	87.39	
AP	0.261	0.266		0.261	0.261	0.261	0.261	
AQ	0.053	0.073		0.0625	0.0625	0.0625	0.0625	
AR								
AS								
AT								
Accept/Reject								

Measured by: <i>K.T.</i>	Date: <i>2019-02-20</i>
Audited by: <i>B.A.</i>	Date: <i>19-02-20</i>
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	<i>[Signature]</i>